

Tuesday, April 21, 2015 1:45:26 PM

Page 1

APR 30 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Tuesday, April 21, 2015 1:45:26 PM

Page 2

Accept

Setup Start *NS1*

Stop *NS2*

Start Date: 4/25/15 **Start Qty:** 2.00 ***2***

Cust Item ID:

Required Date: 4/25/15 **Req'd Qty:** 2.00 ***~***

Customer:

Reference:

Approvals: _____ **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Operation Description

Set Up/ Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
---------	--------	-----------	------------	------------	---------------	-------------

130

Bend as per dwg

0.00

130

Brake NC

Memo

0.00

DAS
30
9-88

2

MAY 05 2015

140

QC6- Inspect dimensions to drawing

0.00

140

OC

Memo

0.00

Quality Control

DAS
38
9-89

2

MAY 05 2015

150

Chemical Conversion Coat per QSI005 4.1

0.00

150

HandFinish

Memo

0.00

Hand Finishing

2 0 15-5-5 Dec

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Work Order ID 131674

Tuesday, April 21, 2015 1:45:26 PM

131674

Page 3

Item ID: D4975-1 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Bracket
 Start Date: 4/25/15 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 4/25/15 Req'd Qty: 2.00 ***2*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC7-Inspect Chemical Conversion Coat	0.00							
160									
QC	Memo	0.00				(2)		DAS 28 9-89	38 9-29
Quality Control									MAY 05 2015
170	Identify as per dwg & Stock Location: <u>WACOB</u>	0.00							
170									
Packaging	Memo	0.00				2		DAS 27 6-89	MAY 05 2015
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.00							
Quality Control									MAY 06 2015

MCS MAY 06 2015

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OTHER : ☐																									

Picklist Print

Tuesday, April 21, 2015 1:45:26 PM

Page 1

Work Order ID: 131674

131674

Parent Item: D4975-1

D4975-1

Parent Item Name: Bracket

Start Date: 4/25/15

Required Date: 4/25/15

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A 14.06.13 AS PER DWG REV.A DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.063

Purchased

No

sf

254.6863

0.052632

M6061T6S 063

①

Jm15-4-30

6061-T6 .063 Sheet

Location

Loc Qty

Loc Code

MAT

54.95

M131653

54.95

MAT021

199.7363

M128941

11.132

M129845

29.7743

M130096

25

M131322

85.83

M131383

48

131322

DQA: _____ Date: _____

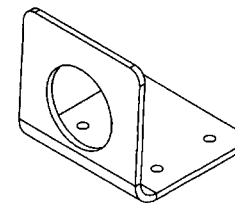
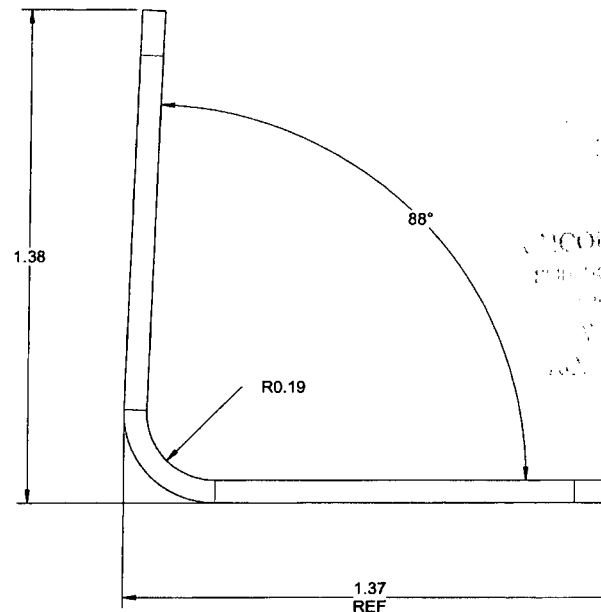
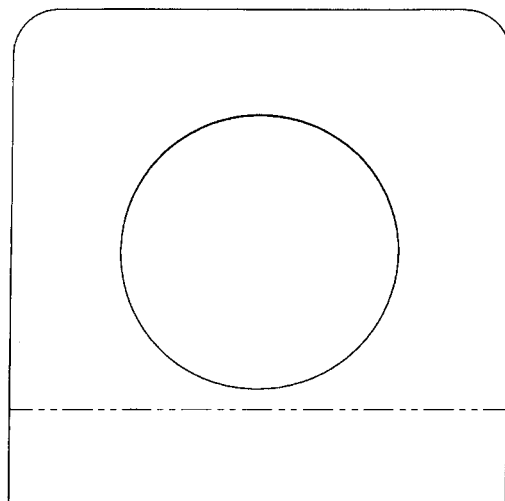


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OTHER : _____						



D4975-1 BRACKET
(MAKE FROM D4975-1F)

NOTES:

- 1) MATERIAL: MADE FROM D4975-1F
- 2) FINISH: APPLY CHEMICAL CONVERSION COATING PER QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

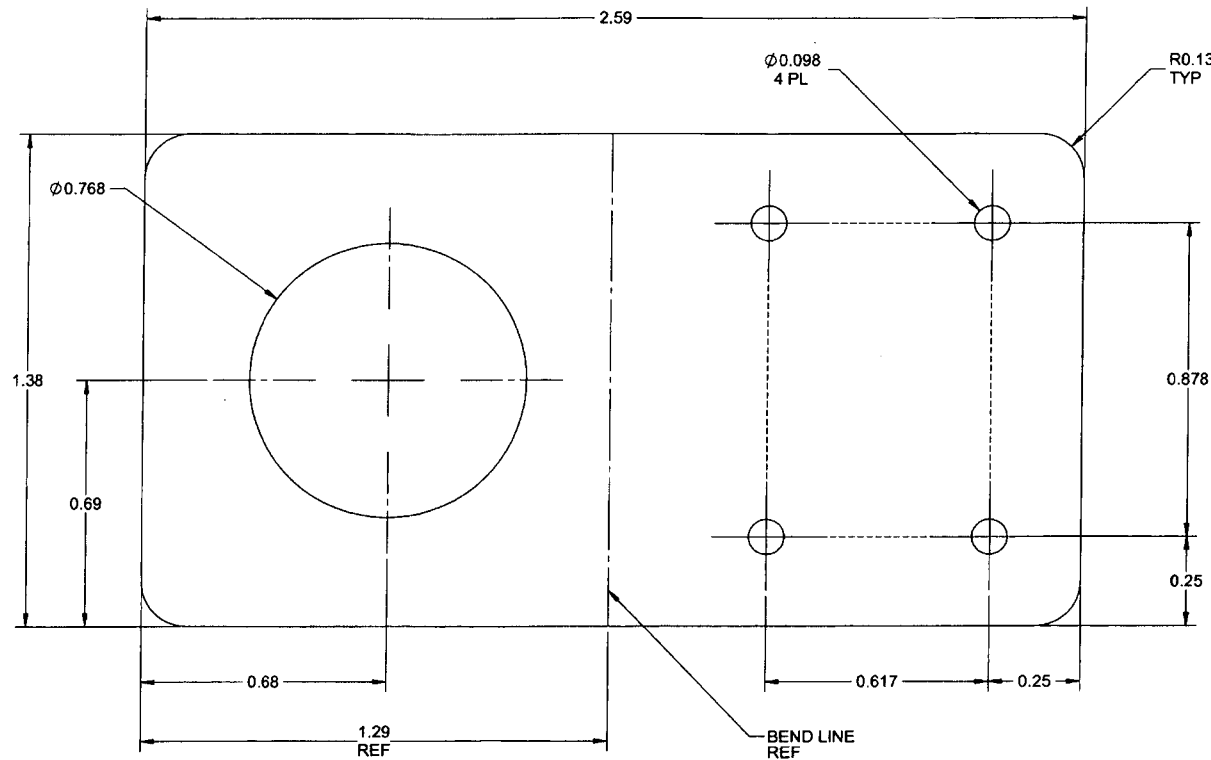
131674 MLJ
1504-22

RELEASED
2014-06-11

APPROVED

A		NEW RELEASE		ML	13.11.12	
REV.		DESCRIPTION			BY	DATE
DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA				
DRAWN	ML					
CHECKED	AP	DRAWING NO.			REV. A	
MFG. APPR.	JLM	D4975			SHEET 1 OF 2	
APPROVED	MP	TITLE			SCALE	
DE APPR.	DS	BRACKET			NTS	
DATE		13.11.12				
COPYRIGHT © 2013 BY DART AEROSPACE LTD						
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL, AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT						

GRAIN
DIRECTION



D4975-1F FLAT PATTERN

RELEASED
2014-06-11

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M6061T6S.063
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

APPROVED

DESIGN	ML	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	ML		
CHECKED	AP	DRAWING NO.	REV. A
MFG. APPR.	JLM	D4975	SHEET 2 OF 2
APPROVED	MP	TITLE	SCALE
DE APPR.	DS	BRACKET	NTS
DATE	13.11.12	COPYRIGHT © 2013 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	